

Date: Tuesday, 28/10/2008 3:25:35 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CUPPED WASHER		
Job Number	: 43033					
Estimate Number	: 12885					
P.O. Number	:			Part Number	: D36281	
This Issue	: 28/10/2008		S.O. No. :	Drawing Number	: D3628 REV B	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	: 33096			Material	:	
Written By	:			Due Date	: 14/11/2008	
Checked & Approved By	: <u>JLD 08.10.28</u>			Qty:	500	Um: Each
Comment	: Est Rev:A New Issue 07-05-28 JLM Est Rev:B Removed Powder 07-07-11 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: Issue P/O: <u>7475</u>	<u>C 20810128</u>
		Email or Ship DXF file to vendor	
		Laser Cut D3628-1 flat pattern and form as per Dwg D3628	
		Possible Supplier: GFI	<u>500</u>
		Material release note is required	
2.0	D36281	Cupped Washer	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 500.0000 Each(s)	
		CUPPED WASHER	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	<u>10/10/26 (600)</u>
		Receive & Inspect For Transit Damage	
		Ensure material certification is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	<u>Stock 10/10/26 (600)</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	<u>Stock 10/10/26 (600)</u>
		Identify with P/N and B/N using a permanent fine point marker on under side of part, then Stock	
		Location: <u>119</u>	<u>S4</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 28/10/2008 3:25:35 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 43033

Part Number: D36281

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/12/01 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MK 08-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

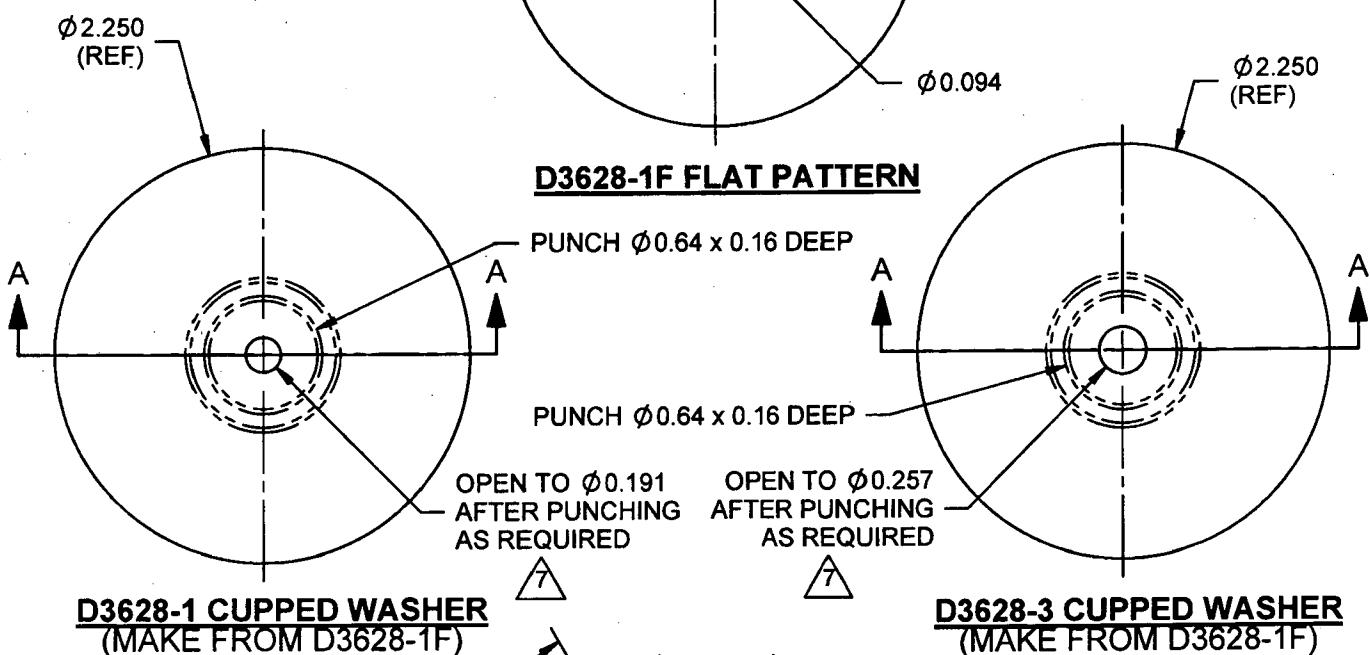
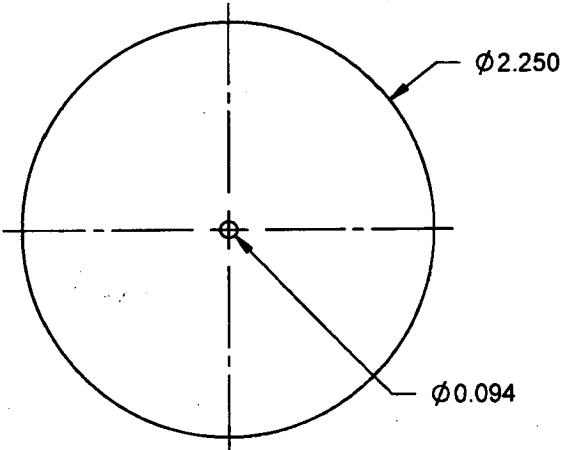
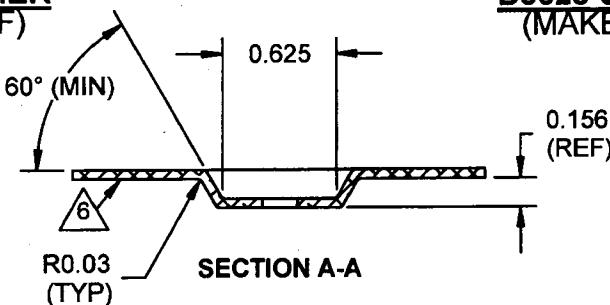
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3628	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE CUPPED WASHER	SCALE 1:1
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE	
REV B	DATE 07.07.09	DESCRIPTION REMOVE POWDER COAT	

RELEASED07.07.09 *CH***D3628-1 CUPPED WASHER**
(MAKE FROM D3628-1F)**D3628-3 CUPPED WASHER**
(MAKE FROM D3628-1F)**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 UNCONTROLLED COPY (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *43033*



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

C'est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/11/24	0408850

VENDEUR / SOLD TO

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° CONTRAT OB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299	J0183024	PO00007475	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
500	D36281	CUPPED WASHER CERTIFICATE OF CONFORMANCE REQ	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

REÇU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE

CEI TIFICAT DE CONFORMITE



Member of / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
120 ABERDEEN ST.
MARKSBURY, ON K6A 1K7

CERTIFICATE NO. **2** OUR JOB NO **10193024** SHIPPING MEMO **0408850**

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
1	500 PCS	PO00007475	D36281	B	CUPPED WASHER	B
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
AMS 5513 304 ANN		TW METALS / ALLEGHENY LUDLUM		H/N # 947041		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT	N FILE	GFI CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **24 NOVEMBER 2008**

G.F.I. Q.C. REP.



DP12-001 REV 0 Bombardier Certificate of Compliance
TW Metals District Procedure

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME: GFI, Inc.

PURCHASE ORDER No. 01 74610

ITEM No. 0001 SHIPPER INVOICE No. 03241965

MATERIAL SIS Sheet SPECIFICATION: AMS 5513

MANUFACTURING MILL: Alleghany

SIZE: .050 HEAT / LOT No. 947041

PART No. TS05848X964 QUANTITY: 2 pc's

TEST DEPARTMENT CLERK Janice Clark

AUTHORITY

Joe Schab
Director of Quality Assurance

*S
6/16/07*

449199582

NOTICE OF SHIPMENT/
PACKING LIST

CUST. ORD. NO. & DATE

01012647

FORMS DISTRIBUTION

CUST. CODE
104/30/08 110977

SOLD TO

SHIP TO

SPEC

SOLD TO

ACCEPTING MILL
NEW CASTLE, IN.
REPEAT ORDER 82037-5
PRIME SEC.
DSO DSO
584SHIPPER NO.
590040
GOVT CONTRACTPRODUCT CODE
13020102060000
MATERIAL 1124
SHIPPING LOCATION NEW CASTLEMILL ORDER NUMBER
30-058-618
INDATE SHIPPED
06/19/08
INVOICE

AL 6168-3 407

CERTIFICATE OF TEST



Allegheny Technologies

CARRIER - KAPLAN TRUCKING
13020102060000 30-058-618
1124 NEW CASTLE IN 076383

GRADE AND SPECIFICATIONS

ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 7) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 10/31/07) (ASTM-A-240-07) (S-1000 DATED 1/2/08) (ASME-SA-240-07) (05/14/08 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) (CONTROLLED TO PWA LCS REQUIREMENTS)

ITEM PCS DIMENSIONS W/G/L

001B 1 48/.050/2122.
P CUST IDENTITY 00624
1 SKID

HEAT # COIL # TEST # GROSS TARE NET THEO TAG #/ CD SKID #

947041 05228N786 7743524 17210 65 17145 169998

17210 65 17145

TYPE HEAT/TEST
HEAT 947041
CHECK 7743524

--C--- --MN-- --P--- --S--- --SI-- --CR-- --NI-- --MO-- --CU-- --N--
.018 1.44 .032 .0005 .34 18.08 8.07 .33 .46 .04
.018 1.46 .031 .001 .35 18.14 8.03 .32 .45 .04

ITEM TEST NO
001B 7743524

PSI * PSI IN 2" % R/A HARDNESS BEND A 262 PR E SIZE
84.HRBW T PASS PASS 9.
82.HRBW

T 41900. 96500. 64.
* Y.S. BY 0.2% OFFSET METHOD

ITEM TEST NO
001B 7743524

MELT P&W E-25
SOURCE TRAN BEND
1. 2.

METALLOGRAPHIC MAGNIFICATION: 100X ETCHANT USED: OXALIC ACID

GRADE VERIFICATION WAS CARRIED OUT SPECTROSCOPICALLY

PAGE 01 - CONTINUED ON PAGE 02

DISCLAIMER: Please Note: This consignment has turned over to carrier in its clean condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceases. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a bill description made by transportation agent on waybill before signing.

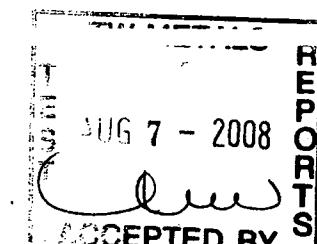
Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an application copy phone 724-228-6577. CAUTION: Processing that makes fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING
Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des renseignements supplémentaires veuillez téléphoner au numéro suivant 724-228-6577. Attention: les traitements entraînant la production de vapeurs, poussières, ou solutions peuvent être cause de maladies pulmonaires. Pour plus de renseignements se référer aux fiches d'information-sécurité.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) set forth in Allegheny Ludlum Order Acknowledgement.

See Mr. Xeraphis
Director, Corporate Quality Assurance

06/19/08 14:09:31



U49199582

NOTICE OF SHIPMENT/
PACKING LIST

CUST. ORD. NO. & DATE

01012647

FORMS DISTRIBUTION

TO

1

SHP

TO

1

SPEC

SOLD TO

CUST. CODE

04/30/08 110977



ACCEPTING MILL

SHIPPER NO.

590040

GOVT CONTRACT

NEW CASTLE, IN.

82037-5 26

PRIME SEC.

DSO DSO

584

PRODUCT CODE

13020102060000

MATL

1124

NEW CASTLE

SHIP TO

CERTIFICATE OF TEST

AL 6158-3 407

MILL ORDER NUMBER

30-058-618

SHIPPING LOCATION

IN

06/19/08

INVOICE

076383

DATE SHIPPED

07/19/08

INVOICE

07/19/08

IN

WORK ORDER TRAVELER

CUST ID: DART

CUST NAME: DART AEROSPACE LTD

CUST P.O.: PO00007475

JOB #

LOT #

PART 1

PART 2

JOB

LOT

DUE

LOT

DATE:

PAGE 1

11/06/08

0193024

01

11/19/08

QTY

500



REVISE
TRACABLE

PART #

D36281

PART DESCRIPTION
CUPPED WASHER

DRAWING # D3628
REV B

OPERATION LIST

OPER W/C

DESCRIPTION

W/I

OPERATIONS RECORDING SECTION

#

ID

10 RELEASE

JOB RELEASE

WRITTEN BY: Y.D.

DWG: D3628 REV: B

L/Y: D3628-1 REV: B

AMD: A44383 REV: B

REL 11-14 10/2

20 AMADA

N/C PUNCHING

USE .050 SST 304 48 X 96

IT MAKES (666) PCS/SHEET

PROGRAM: A44383

RECORD THE FOLLOWING DATA

MAT. HEAT CODE: 847C 44

MAT. P.O.: 74612

94071

30 DRILL

DRILLING OPERATION

OPER INT: _____ QTY: _____

INSP: _____

OPEN (1) HOLE TO
.191 +.005/-001 DIA.

40 DEBURR

DEBURRING BY HAND

7.5 WI-5 OPER INT: _____ QTY: _____

INSP: _____

DEBURR

50 INSPECTION

INSPECTION STATION

OPER INT: _____ QTY: _____

INSP: _____

FINAL INSPECTION
MARKING MADE BY CUSTOMER

60 SHIPPING

PACKING AND SHIPPING

7.5 WI-4 OPER INT: _____ QTY: _____

INSP: _____

PACK AND SHIP

MATERIAL LIST

PART

DESCRIPTION

QTY

#

TS05048X964A

.050"X48"X 6 AMS-5513 304 ANN.

REQ

1

